

CLAIMS

1. A method of separate application of resin and hardener components of an amino resin gluing system onto a substrate, characterized in that the hardener comprises a filler in an amount of less than 20% by weight and a volatile acid, wherein the components of the gluing system are applied in the form of strands or by means of spraying, or any combination thereof, in optional order of application.

2. A method according to claim 1, characterized in that the resin component is applied in the form of strands, whereafter the hardener component is applied by means of spraying.

3. A method according to claim 1, characterized in that the components of the gluing system are separately applied, in the form of strands, in optional order, onto the substrate.

4. A method according to claim 3, characterized in that the later applied strands of one component substantially overlap the corresponding previously applied strands of the other component(s).

5. A method according to claim 4, characterized in that the hardener component is applied in the form of strands on top of the resin component applied in the form of strands.

6. A method according to claim 3, characterized in that the later applied strands of one component do not overlap the corresponding previously applied strands of the other component(s).

7. A method according to claim 3, characterized in that the later applied strands of one component do not contact the corresponding previously applied strands of the other component(s).

8. A method according to claim 1, characterized in that the hardener comprises volatile acid in an amount of 10-30 % by weight.

9. A method according to claim 1, characterized in that the weight ratio of hardener to resin is 1:3,5-1:2.

10. A method according to claim 1, characterized in that the resin component is selected from the group of melamine-urea-formaldehyde, urea-formaldehyde, or melamine-formaldehyde resins.

11. A method according to claim 1, characterized in that the hardener comprises a filler in an amount of less than 10% by weight.

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12. Hardener composition for use in the method of any of the claims 1-11, characterized in that it comprises a filler in an amount of less than 20 % by weight and a volatile acid.

13. Hardener composition according to claim 12, characterized in that it comprises volatile acid in an amount of 10-30 % by weight.

14. Hardener composition according to claim 12 or 13, characterized in that the volatile acid is formic acid, acetic acid, or pyrovic acid.

15. Hardener composition according to claim 12, 13 or 14, characterized in that it comprises a filler in an amount of less than 10% by weight.

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